



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3642-1

Job Sheet 171370



Part No: D3642-1

Job Qty: 8 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 1/31/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	1/30/18	1/30/18	0.00	0.00	Start Up Waterjet		SC 8/01/31
100	Waterjet	8 pcs	1/30/18	1/30/18	0.00	0.72	Waterjet1		SC 8/01/31
110	QC	8 pcs	1/30/18	1/30/18	0.00	0.00	QC2 Waterjet-2		SC 8/01/31
120	QC	8 pcs	1/30/18	1/30/18	0.00	0.00	QC8-3		SC 8/01/31
130	HandFinish	8 pcs	1/31/18	1/31/18	0.00	0.46	HandFinish1		18-02-055
140	QC	8 pcs	1/31/18	1/31/18	0.00	0.00	QC3		11 FEB 05 2018
150	Packaging	8 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3		9-89
160	QC21-SA	8 Ea	1/31/18	1/31/18	0.00	0.00	QC21		21 FEB 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.3312 sf (.1664 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	1 (1.67)	131	0

Part Specifications

Specifications could not be found.

Plex 1/31/18 11:42 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S037680



Doubler

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CANADA
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PART NO: D3642-1
Original Serial #: S037680
Revision:
Operation:
Change No:

Start up Operation 01/31/18
Job No: 171370

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order:	171370
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642	Rev: B	Page 1 of 1	

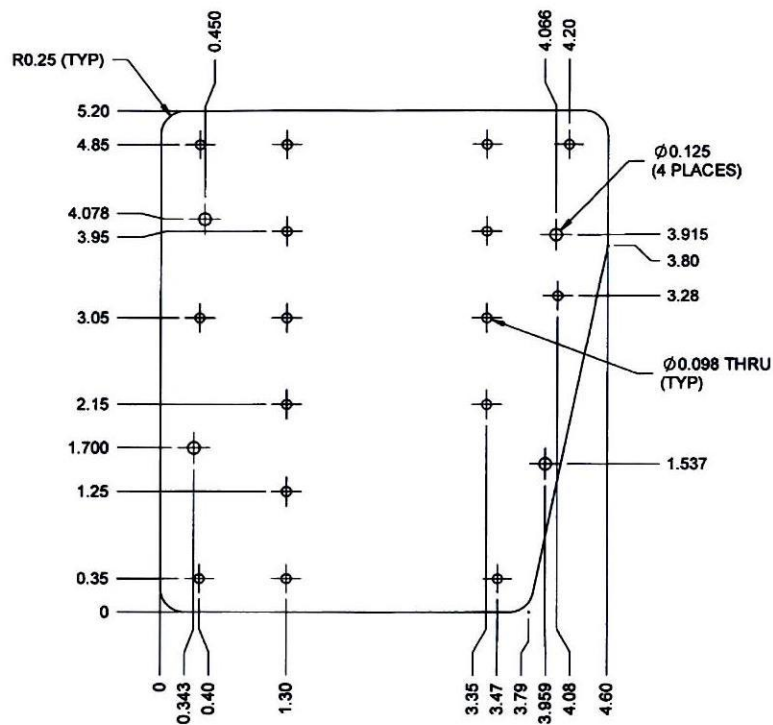
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	Ø0,126	1		VDC-02	
Ø0.098	+0.004/-0.001	Ø0,099	1			
0.35	+/-0.030	0,349	1			
1.25	+/-0.030	1,254	1			
1.700	+/-0.010	1,698	1			
2.15	+/-0.030	2,147	1			
3.05	+/-0.030	3,055	1			
3.95	+/-0.030	3,948	1			
4.078	+/-0.010	4,079	1			
4.85	+/-0.030	4,848	1			
5.20	+/-0.030	5,195	1			
0.343	+/-0.010	0,344	1			
0.40	+/-0.030	0,407	1			
1.30	+/-0.030	1,298	1			
3.35	+/-0.030	3,349	1			
3.47	+/-0.030	3,468	1			
3.79	+/-0.030	3,788	1			
3.959	+/-0.010	3,960	1			
4.08	+/-0.030	4,086	1			
4.60	+/-0.030	4,606	1			
1.537	+/-0.010	1,538	1			
3.28	+/-0.030	3,278	1			
3.80	+/-0.030	3,799	1			
3.915	+/-0.010	3,916	1			
0.450	+/-0.010	0,451	1			
4.066	+/-0.010	4,067	1			
4.20	+/-0.030	4,208	1			

Measured by: SC	Audited by: EB	Prototype Approval:	N/A
Date: 18/01/31	Date: FEB 01 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	



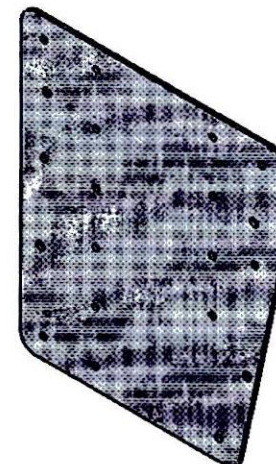
D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171370

JAN 30 2018



RELEASED
01.11.14

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	UC		
CHECKED	AB	DRAWING NO.	REV. B
MFG. APPR.	EC	D3642	SHEET 1 OF 1
APPROVED	TH	TITLE	SCALE
DE APPR.		DOUBLER	4:5
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	